

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008475**Date Inspected:** 15-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:****Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:****Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing(Gate To Gate)

The QA Inspector performed, gate to gate Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications. Panel identification number is DP-240-001.

The Y locations of indication for the panel were marked and recorded as:

DP-240-001(11CW)

Total Number of Ribs -05

Total Number of Tack Welds -280

Total Number of Tack Welds Scanned -196

Weld 04: Tack Welds Scanned - 28, Indication Observed - 03

Weld 05: No Indication

Weld 06: Tack Welds Scanned - 28, Indication Observed - 02

Weld 07: Tack Welds Scanned - 28, Indication Observed - 03

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Weld 08: No Indication

Weld 09: Tack Welds Scanned - 28, Indication Observed – 02

Weld 10: Tack Welds Scanned - 28, Indication Observed – 02

100% of UT Gate To Gate for Deck Panel DP-240-001 Tack welds was not completed during this inspection shift.

Remaining Weld to be completed W1,W2 and W3.

Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (PAUT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (marked for crack confirmation) which were previously tested by Caltrans QA personnel. The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications.

Panel identification numbers are

DP-238-001(11AW)

DP-239-001(11BW)

Initial Visual Inspection for Deck Panel

This QA inspector performed Initial Visual Inspection for Deck Panel weld repair area which was previously marked by ZPMC Quality Control personnel and ABF QA personnel. The member is identified as OBG Deck Panel.

The Panel is as follows:

DP-455-001(11BE)

Green Tagging for Deck Panels:

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as OBG Deck Panels.

The Panels are as follows:

DP-343-001(10AE) Green Tag No:007870

DP-479-001(10BE) Green Tag No:007869

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as

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OBG Deck Panels.

The weld designations reviewed are as follows:

DP-343-001(10AE) Weld No. W1,W2 and W3

DP-479-001(10BE) Weld No. W2,W3 and W4

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis
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Quality Assurance Inspector

Reviewed By:	Prue,Erik
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QA Reviewer
